

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012262**Date Inspected:** 25-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

6AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 062, 064, 066 and 068 located at SP566-001 panel point 40 on the cross beam side of segment. Welder is identified as Mr. Zhao Guanglin (044779). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1, WPS-B-P-2114-FCM-1 and ABF-RFI-002004R00.

Shield Metal Arc Welding (SMAW) welding was performed on weld joints 061, 063, 065 and 066 located at SP566-001 panel point 40 on the cross beam side of segment. Welder is identified as Mr. Chen Renzhi (058087). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2112-FCM-1 and ABF-RFI-002004R00.

7AW+7BW

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 002 located at OBW7 on the counter weight side of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2213-Tc-U4b-1.

### NDT Observation

This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician performed MT on various locations in the trial assembly yard. Locations are as followed:

#### 6CW

1. MT being performed on the edge plate T stiffener located at panel point 44.5 cross beam side of segment.

This QA Inspector observed ZPMC Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Locations are as followed:

#### 6BW+6CW

1. UT being performed on the bottom plate T stiffener web to web welds.

#### 6BE+6CE

1. UT being performed on the edge plate stiffeners located on the bike path side of segment.

#### 6BE+6CE

During random in process observations of heat straightening of side plate to corner assembly weld splice, this QA Inspector observed heat straightening was performed on the exterior surface of splice weld while rain water was present in segment. Neither a digital temperature gage nor a temp stick was present to monitor heat input at the time of work. This QA Inspector issued an incident report for today's work shift.

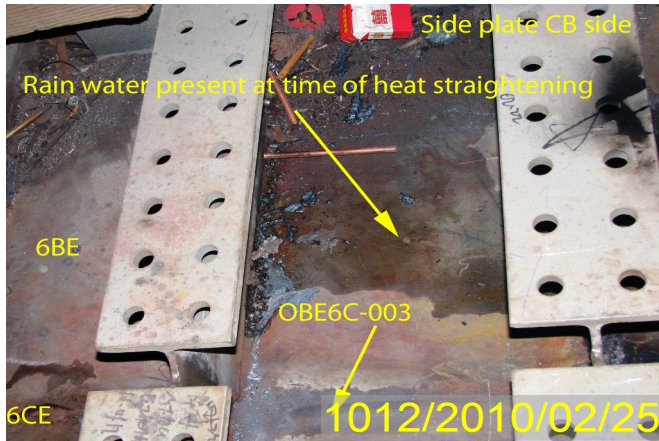
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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